

Date: Monday, 3/26/2007 3:03:44 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FUEL PANEL SHEILD
Job Number : 31512	
Estimate Number : 12810	
P.O. Number : <i>N/A</i>	Part Number : D36091
This Issue : 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3609 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0001
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>JLM 070326</i>	Due Date : 4/2/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-03-26 JLM	

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 M304S22GA

304/316 .032 Sheet



Comment: Qty.: 0.5256 sf(s)/Unit Total : 0.5256 sf(s)

304/316 .032 Sheet

Batch: *M102159**ml 07 03 27*

①

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3609

Dwg Rev: *U/R*Prog Rev: *U/R**ml 07 03 27*

①

2-Debur if necessary

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07 03 28*

①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK

ENGINEERING
APPROVAL*07.04.03*

Comment: SECOND CHECK

07.04.03

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

07.04.03

①

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PANEL SHEILD

Job Number: 31512

Part Number: D36091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

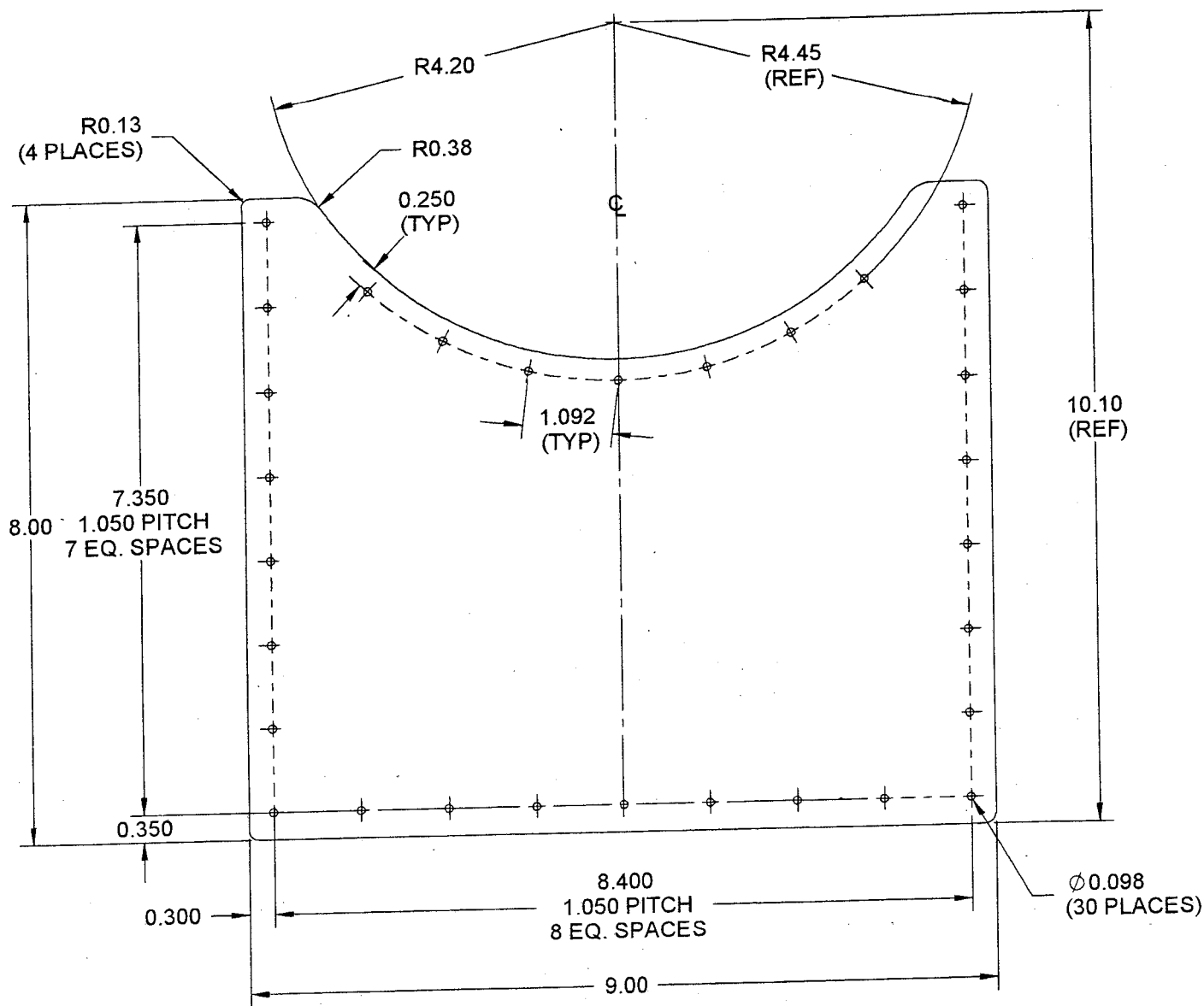
Job Completion



60071
A 07/04/05

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3609	REV. A SHEET 1 OF 1
DATE 07.03.13	TITLE FUEL PANEL SHIELD		SCALE 1:2
REV A	DATE 07.03.13	DESCRIPTION NEW ISSUE	



D3609-1 FUEL PANEL SHIELD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 24 GAUGE (0.025 THICK)
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT C

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DART AEROSPACE LTD		Work Order: 31512
Description: Fuel Panel Shield		Part Number: D3609-1
Inspection Dwg: D3609 Rev: D/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø 0.098	+0.004 - 0.001	0.102	✓		vern	
B	8.00	+1 - 0.030	8.00	✓		vern	
C	9.00	+1 - 0.030	9.00	✓		vern	
D	0.300	+1 - 0.010	0.300	✓		vern	
E	8.400	+1 - 0.010	8.400	✓		vern	
F	1.050	+1 - 0.010	1.050	✓		vern	
G	R0.13	+1 - 0.030	R0.13	✓		vern	
H	0.350	+1 - 0.010	0.349	✓		vern	
I							
J							
K							
L							
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N							
O							
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Q							
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T							
U							
V							
W							
X							
Y							

Measured by: <i>md. m</i>	Audited by: <i>E</i>	Prototype Approval: <i>N/A</i>
Date: 07.03.28	Date: 07.04.03	Date: <i>N/A 07.04.03</i>
Rev	Date	Change
		New Issue
		Revised by
		KJ/RF
		Approved